Work Orde May-13-13 1:10	er ID 10165		D 3.065-5	*10	1655	5 *	T-700 (1225) 1 (1	 .				Page 1
Revision ID:	D3065-5 Step Leg]	B 101655	Accept	*N9	300 300	040			etup Star	I VI	S1* S2*
Start Date: Required Date: Reference:		art Qty: 160.00 q'd Qty: 160.00	*160* *160*			st Item I stomer:	D:					
Approvals:	Process Plan: QC:		Date: 13-05-15				nte:		R	tun Star Sto _l	17	R1* ` R2*
Sequence ID/ Work Center II		eration cription		Set Up/ Run Hours	T	ool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr										
D3065	Rev B	:										
*100 *100 *Materjet FLOW CNC Waterjet		OW WATER JET Memo 1-Cut as per if necessary	Dwg D Dwg Rev:	0.00 0.00 Prog Rev: B	2-Deburr			***	150	- 0		Jm13-07-08
110	QC2	2- Inspect parts off ma	achine FAI/FAIB	0.00					150)		
110 QC Quality Control		Мето	N	0.00					450	<u> </u>		Jm13-07-08
*120	QC8	8- Inspect parts - seco	nd check	0.00					iSc.		,	
QC Quality Control		Memo		0.00 B	lD				Cain	1		

and the state of t

NCR: Ye	es / No				WORK ORDER NON-	CON	IFORM	MANCE / UP	DATE			
					· · · · · · · · · · · · · · · · · · ·				* . *	QA Closed:	Date	::
Work Orde	r·				DISPOSITION			•	AGAINST DE	PARTMENT,	/PROCESS	
Work Order	-				Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o	-			Work Order Update]		Large Fab	Composite		Supplier	
Root	•			Descri	ption of work order update	l li	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data				· · ·					***			
Equip/Tooling		ļ				ĺ			:			
Operator		Į.]]									
Material												·
Setup	_											
Other	_					1						
Process												
Supplier	_		.									
Training												·
Unapproved		<u> </u>	<u>. </u>					<u> </u>			<u></u>	
		-				AUL	T CATE	GORY				
Landin	ig Gear			r	General					1		¬_
-	Bending	_			Bend	\vdash	Grain		<u> </u>	Ovalized	-	Pressure/Forced
-	Centre N	ot Concei	ntric to (^{D/S} -	BOM/Route	\vdash	Hardwa		_	Over/Under	<u> </u>	Temperature/Cure
	Cracks			-	Broken/Damaged			ion incomplete		Part Incorre	<u></u>	Weld
	Crushed/	Crimped		<u> </u>	Burrs	\blacksquare		tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
}	Cuffs				Contamination	\vdash	Mainte		<u> </u>	Part Moved		
}	Heat Trea		- 1	<u> </u>	Countersink		Mislabe		<u> </u>	Positioned V	· · · -	704
}	Inspectio		Tube	 	Cut Too Short		Misread	đ		Power Loss/	Surge	Other
}	Ripples in			<u> </u>	Drill Holes	\vdash	Offset	.				
	Torque V			ր <u> </u>	Drawing	-		Calibration -				***
ļ.	Turning S	•		<u> </u>	Finish	-		Sequence				
	Wave/Tv	vist in Tul	be	1	Folio		Outside	Dimensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde <i>May-13-13 1:10</i>		655		*101	655*			Page 2	
Revision ID:	D3065-5 Step Leg			Accept	*N90004010	N* Setup	Start Stop	*NS1* *NS2*	-
Start Date: Required Date: Reference:	5/13/13 5/24/13	Start Qty: 160.00 Req'd Qty: 160.00	*16(*16(Cust Item ID: Customer:				
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):	Date:	Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II 130 *120* HandFinish Hand Finishing	D	Operation Description Chemical Conversion Coa	at per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code			eject Insp. umber Stamp	
140 *140* QC Quality Control		QC3- Inspect Part Finish Memo		0.00	30 30	(78		nsle	29/29
150 *15 \ *		Identify as per dwg & Sto	ck Location: CA	0.00		100		B	17/03/

0.00

Memo

150 Packaging

Packaging

												DQA:	Dat	te:	
NCR:	'es	/ No				WORK ORDER NON-C		NFORM	MANCE / UP	DATE		·		-	
		-										QA Closed:	Da	te:	
Work Orde	or.				·	DISPOSITION				AGAINST D	ΕΙ	PARTMENT	/PROCESS		
Part f	- ۱٥٠				······································	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	ı	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data			1							•					
Equip/Tooling							l	Ì							
Operator			ļ				ļ							ļ	
Material			ļ	,										1	
Setup							ļ							1	
Other															
Process							ļ								
Supplier							l								
Training															
Unapproved															
						F	AUL	T CATE	GORY						····
Landi	ng (Gear				General		-		_		•			•
		Bending				Bend .		Grain		_		Ovalized		_	Pressure/Forced
ļ		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re			Over/Under	tolerance	_	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	issing	L	Wrong Stock Pulled
1		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l			Power Loss/	Surge		Other
	Г	Rinnles in	Bend			Drill Holes	Г	Offset		_		_			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord <i>May-13-13 1:</i>		01655			*101	655*							Page
Item ID: Revision ID: Item Name:	D3065-5 Step Leg	- · · · · · · · · · · · · · · · · · · ·		Acce	ept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Dat Reference:	5/13/13 e: 5/24/13	Start Qty: 160.00 Req'd Qty: 160.00		*160* *160*		Cust Item I Customer:	D:						,
Approvals:	Process P QC:	lan:	Date:		ooling: PC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

0.00

QC21- Final Inspection - Work Order Release

Memo

Quality Control

160

160

0.00

MLJ 13-07-30 MLJ 13-07-29

Page 3

										DQA:	Date:	
NCR: Y	es /	No			WORK ORDER NON-O	100	VFORN	AANCE / UP	DATE			
				·					·	QA Closed:	Date:	
Work Orde	ař.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE	·· —				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing	1	re/Packaging	Other
NCR N	No				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	П	nitial	Ac	tion	Sign &		
Cause	D	ate Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data					•							
Equip/Tooling												
Operator											:	
Material				ļ								
Setup			ļ	1								
Other	Ш		ł	ĺ			:			j i		
Process												
Supplier												
Training			1									
Unapproved										<u> </u>	<u> </u>	<u> </u>
					F	AUL	T CATE	GORY				
Landi	ng Gear			_	General	_			_	3		7
	Ber	ding		L	Bend	_	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	Cer	tre Not Conc	entric to	o/s	BOM/Route	L	Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cra	cks			Broken/Damaged	_	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Cru	shed/Crimpe	d		Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuf	fs			Contamination		Mainte	nance		Part Moved		
	Hea	t Treat			Countersink		Mislabe	led		Positioned V	Vrong	-
	Ins	ection Strip	in Tube		Cut Too Short	L	Misread	1		Power Loss/	Surge	Other
	Rip	oles in Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Page 1

Work Order ID:

101655

Parent Item:

D3065-5

Parent Item Name:

Step Leg

Start Date: 5/13/13

Required Date: 5/24/13

Start Qty: 160.00

Required Qty: 160.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	111.0973	0.825	138.94738	}	Jr	ns 07-0
0001-16 .080 Sneet				Location		Loc Oty	<u>Lo</u>	c Code	 	140	* ************************************	-, ,	
				MAT021		111.097264			 				
					7285 4786	0.497264 110.6			OH	70%			
				12	581Z				128	<i>S81</i> 3.			

NCB.	Yes / No	WORK ORDER NO
NCK.	res / No	WORK ORDER INC

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____Date: _____

WCIN.	cs / 140				WORK ORDER NOR			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		QA Closed:	Da	te:
Work Orde	r·	·			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Quality
NCR N	0				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	
Root				Descr	iption of work order update	lr	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verificatio	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup												
Other												
Process					•							
Supplier	_			ē								
Training	_	ŀ										
Unapproved		<u> </u>									<u> </u>	
						FAUL	CATE	GORY				
Landin	ng Gear			_	General	r1			_	7		<u> </u>
1	Bending				Bend		Grain			Ovalized		Pressure/Forced
1	Centre No	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under		Temperature/Cure
1	Cracks			<u> </u>	Broken/Damaged		•	ion Incomplete		Part Incorre		Weld
	Crushed/	Crimped		<u> </u>	Burrs	\vdash		ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte		<u> </u>	Part Moved		
	Heat Trea			<u> </u>	Countersink		Mislabe		<u> </u>	Positioned V	•	 1
	Inspectio	-	Tube	Ĺ	Cut Too Short		Misread	d	L	Power Loss/	Surge	Other
]	Ripples in	n Bend			Drill Holes		Offset					
	Torque W	Vaves in I	Extrusio	n L	Drawing		Out of (Calibration				
	Turning S	Sequence	!		Finish		Out of 9	Sequence				
	Waye/Tu	ist in Tul	ho		Folio		Outside	Dimensions				

DART AEROSPACE LTD	Work Order:	101655
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		 				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	-		1	J/ma6
15.750	+/-0.005	15.750	_		T	
2.250	+/-0.005	2.254"	_		V	Jemoi
3.460	+/-0.005	3.463	-		· V	
0.865	+/-0.005	0.863"			V	
6.020	+/-0.005	6.021	-		V	
1.205	+/-0.005	1.207"	_		ν	
3.484	+/-0.005	3.481"	_		ν	
0.871	+/-0.005	0.870"	_		V	
8.325	+/-0.010	8.327	-		V	Productors
0.551	+/-0.010	0.551	-		ν	
0.213	+0.005/-0.000	0.214	_		V	
Ø0.128	+0.005/-0.000	0.129"	1		V	
	•					

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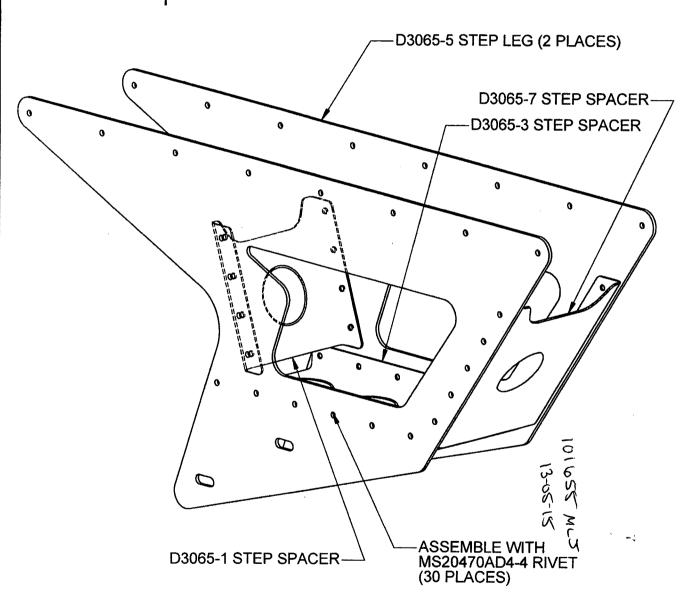
Measured by: Jm	Audited by:	30	Prototype Approval:	N/A
Date: 13-03-08	Date:	137-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM 140	-1
С	06.06.23	Dwg Rev. changed	KJ/JLM	
				- 7~/



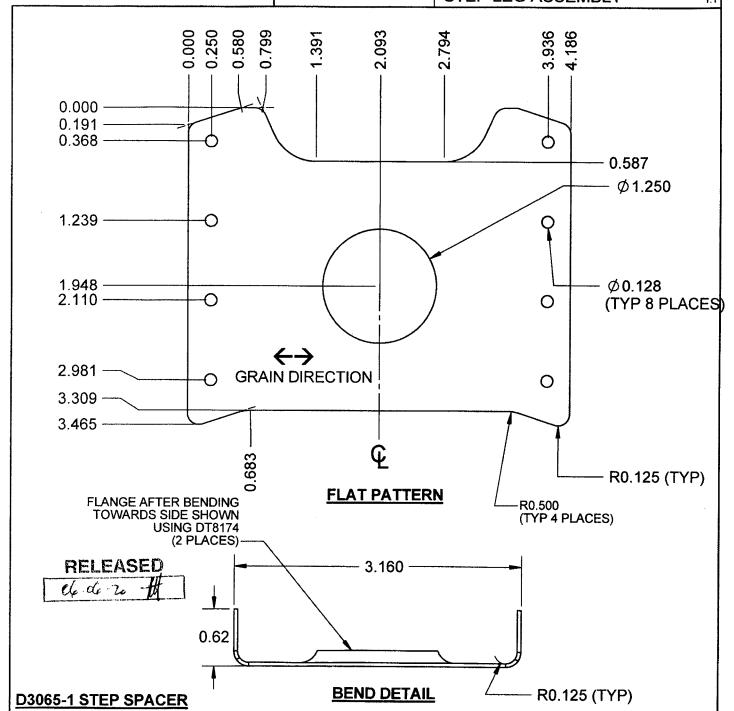
DESIGN A DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECK		APPROVED	DRAWING NO.	REV. B	
	PH	THE	D3065	SHEET 1 OF 5	
DATE	06.05.23		TITLE	SCALE	
06.05.23			STEP LEG ASSEMBLY	1:2	
Α	02.09.11		NEW ISSUE		
В	06.05.23		ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED Control



D3065-041 STEP LEG ASSEMBLY





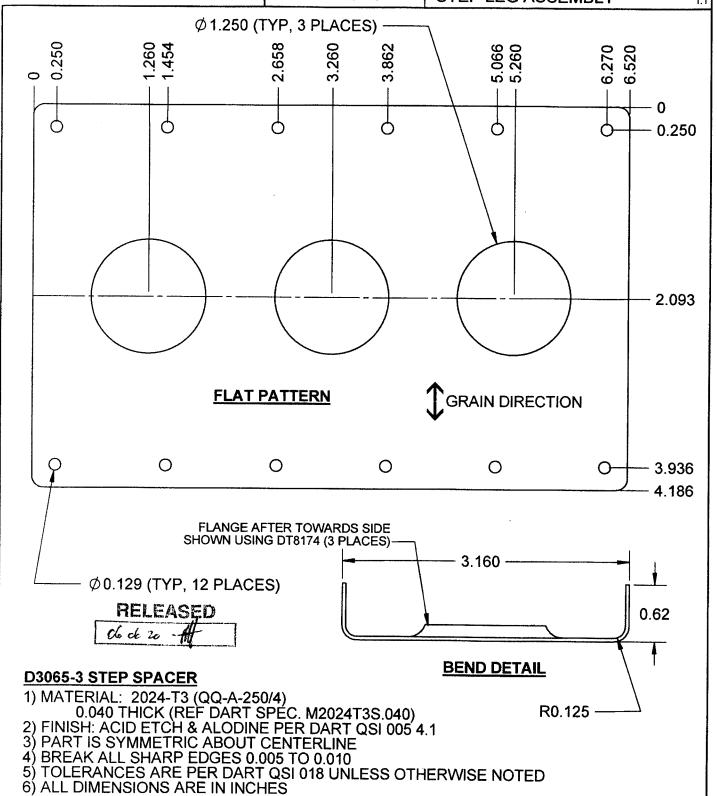
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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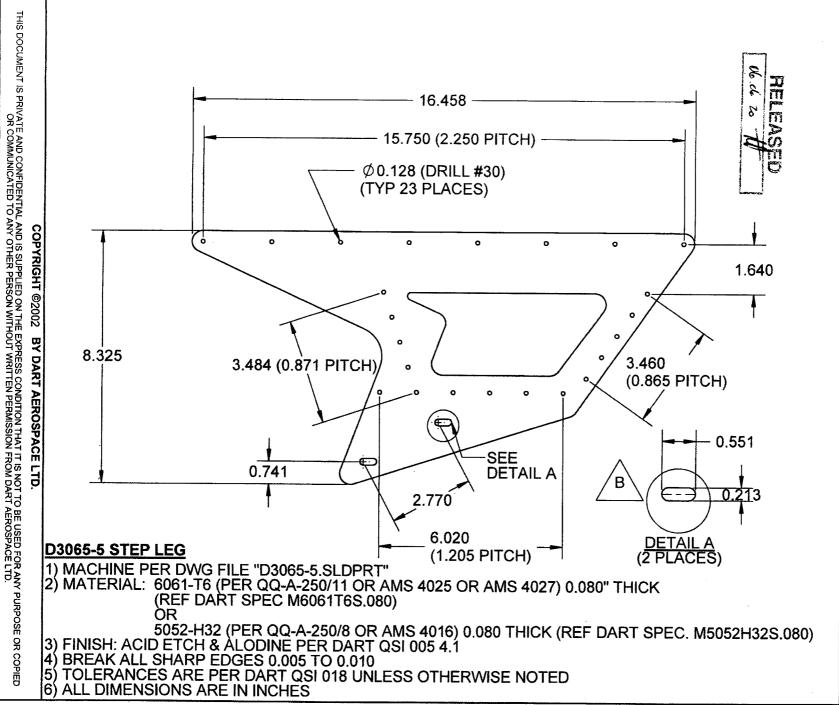






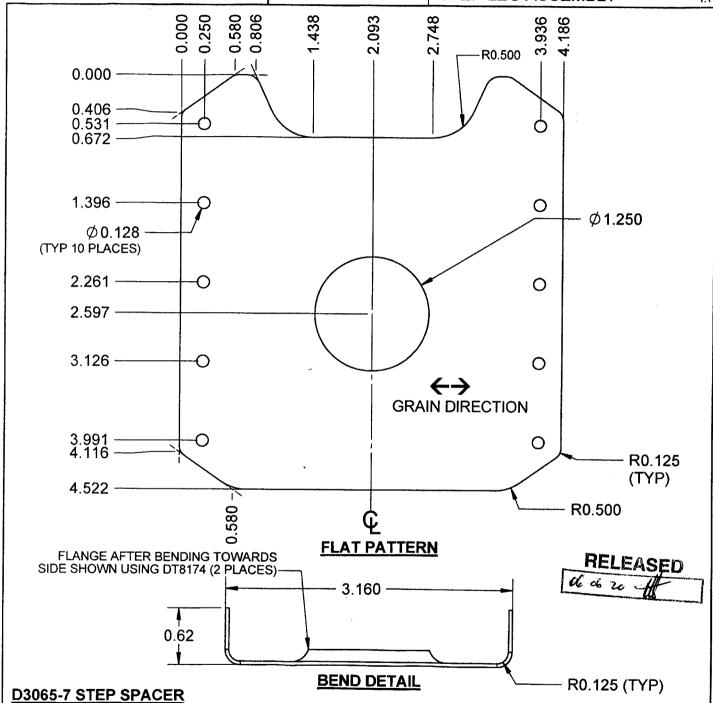


DATE 06.05. 72 23 \mathcal{P} DRAWING NO. STEP DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA G **ASSEMBLY** SHEET 4 OF 5 REV. B SCALE









- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 3) PART IS SYMMETRIC ABOUT CENTERLINE

- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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